

Date: Monday, 4/10/2006 11:12:47 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLOWER MOTOR INLET ADAPTER
Job Number : 26597	
Estimate Number : 12247	
P.O. Number : N/A	Part Number : D3477041
This Issue : 4/10/2006 S.O. No. : N/A	Drawing Number : D3477 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 26178	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 4/28/2006 Qty: 7 Um: Each
Checked & Approved By : <u>SA 06.04.10</u>	
Comment : Est Rev A New Issue 06-02-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34773	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3477-3	Tube	B26598

SB 06/04/26 (7)

2.0	D34771	Flange
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3477-1	Flange	B26130

SB 06/04/26 (7)

3.0	D34775	BLOWER ADAPTER FLANGE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3477-5	Flange	B26131

SB 06/04/26 (7)

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3477

2-Spot Weld as per Dwg D3477 and Dart QSI 004

SB 06/04/26 (7)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 06/04/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/10/2006 11:12:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR INLET ADAPTER

Job Number: 26597

Part Number: D3477041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

WELD INSPECTION



Comment: WELD INSPECTION

17 Dec 04-26 (7)

6.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: _____

Electro Chemically Polish weldment as per Dwg Dwg D3477

Ensure Certificate of Conformity is attached

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

18 Dec 04-26 (7)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

19 Dec 04-26 (7)

Job Completion



11 Dec 04-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

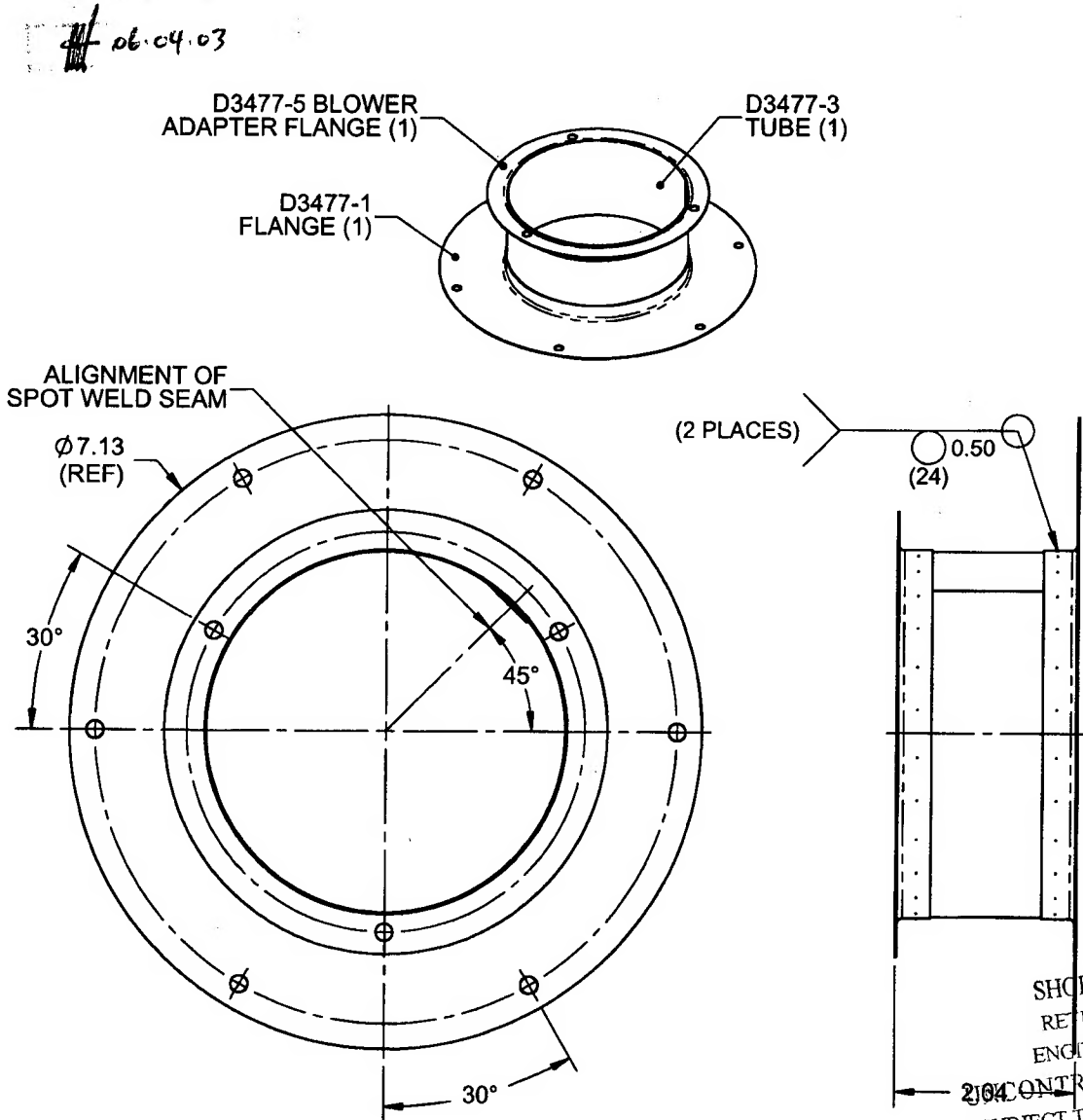
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3477	REV. A SHEET 1 OF 4
DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2
A	05.12.09	NEW ISSUE	

**D3477-041 BLOWER MOTOR INLET ADAPTER****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3477-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

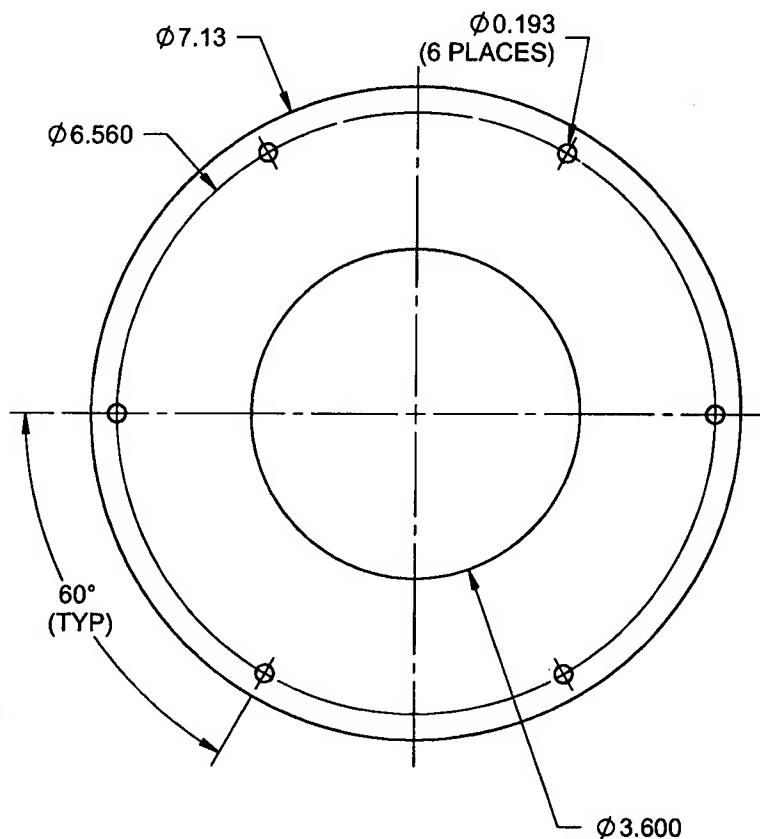
QTY -041	P/N	DESCRIPTION
X	D3477-041	BLOWER MOTOR ASSEMBLY
1	D3477-1	FLANGE
1	D3477-3	TUBE
1	D3477-5	BLOWER ADAPTER FLANGE

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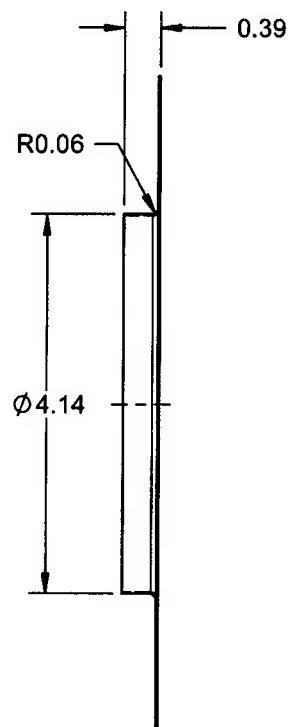
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DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2



D3477-1F FLANGE
FLAT PATTERN



D3477-1
FLANGE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

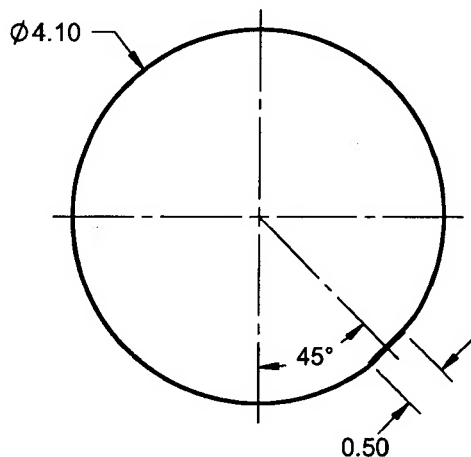
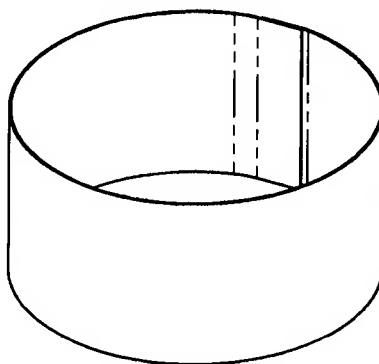
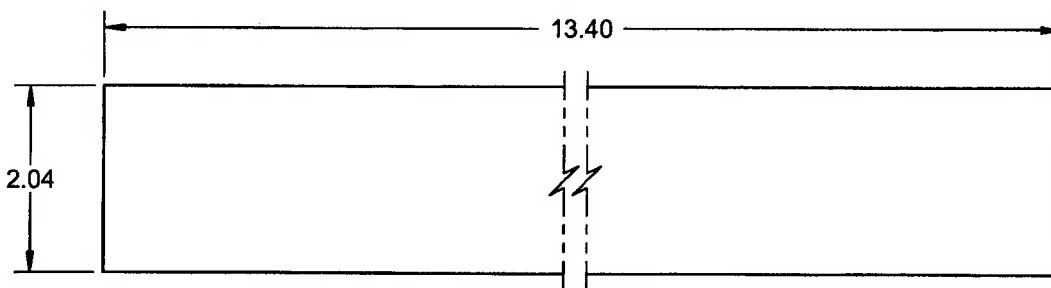
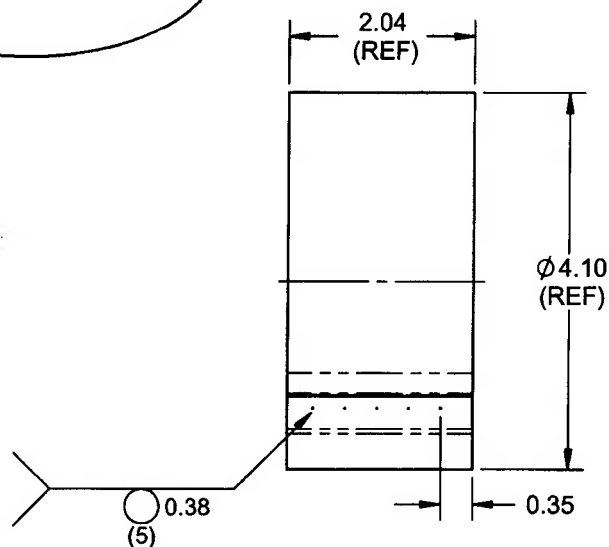
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DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2

06.04.03**D3477-3 TUBE****D3477-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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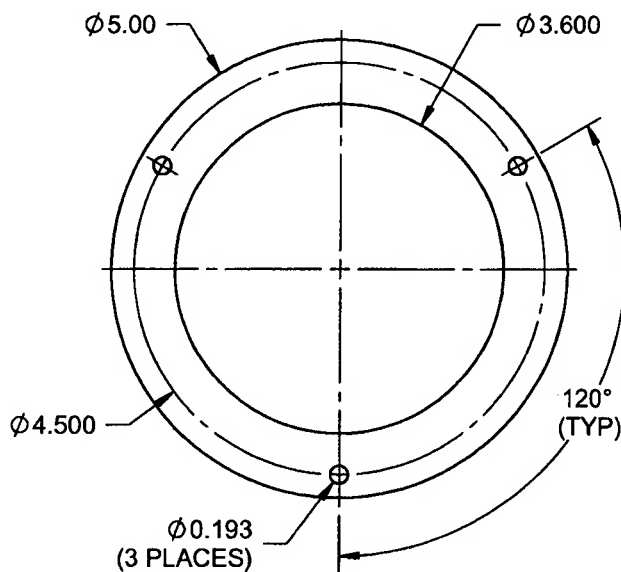
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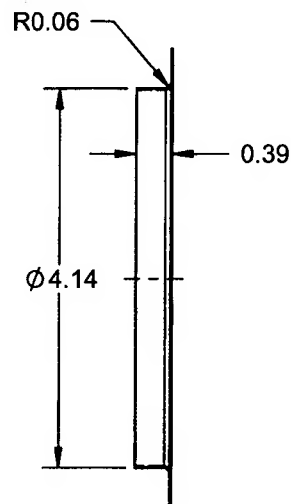


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DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2

06.04.03



D3477-5F FLAT PATTERN



**D3477-5 BLOWER
ADAPTER FLANGE**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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